

Tuesday, November 08, 2016 10:51:58 AM

Page 1

DAS

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr						DAS 46 9-89		
D4435	B							16/11/17	
100		0.00							
100	FLOW WATER JET								
Waterjet	Memo	0.02				2			
FLOW CNC Waterjet	1-Cut D4435-3 as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary								
110		0.00							
110	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00				2	DAS 46 9-89	16/11/17	
Quality Control									
120		0.00							
120	QC8- Inspect parts - second check								
QC	Memo	0.01				2	DAS 38 9-89		
Quality Control									

NOV 18 2017

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Page 2

Item ID: D4435-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mount Bracket Assembly

Start Date: 11/23/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/29/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00							
130									
HandFinish	Memo	0.02				(K2)	Ø		2016/11/21 BER.
Hand Finishing									
135	QC7-Inspect Chemical Conversion Coat	0.00							
135									
QC	Memo	0.00							2 Ø 16-11-23 DAS 34 9-89
Quality Control									
140	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.01							2 Ø 16-11-23 DAS 34 9-89
Powder Coating	START TIME: 11:20 OVEN TEMPERATURE: 300° FINISH TIME: 11:53								

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Item ID: D4435-043

Revision ID:

Item Name: Mount Bracket Assembly

Start Date: 11/23/2016 Start Qty: 2.00

Required Date: 11/29/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

DAS
38
9-89

NOV 23 2016

160

0.00

160

Small Fab

Memo

0.05

Small Fab

1- Cut rubber seal at 3.70"
2-Glue rubber seal to bracket as per dwg (SHEET 1, NOTE 8)

1134871

2

FF

DEC 09 2016

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.01

Quality Control

DAS
38
9-89

DEC 09 2016

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Item ID: D4435-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mount Bracket Assembly
Start Date: 11/23/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 11/29/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>Store</u>	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.03							
Quality Control									

2 DEC 13 2016 DAS 6 9-89
DAS 21 9-89 DEC 14 2016
MF 16-12-13

Picklist Print

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Page 1

Work Order ID: 153078

153078

Parent Item: D4435-043

D4435-043

Parent Item Name: Mount Bracket Assembly

Start Date: 11/23/2016

Required Date: 11/29/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.10.05 NEW ISSUE DD VERF:EC
12.03.06 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4441-1

Manufactured

No

160

f

0.0001

0.308

0.616

D4441-1

FF

DEC 0 9 2016

Rubber Seal

Location

Loc Qty

Loc Code

ST422

11151347

0.0001

120932

0.0001

0.616

M6061T6S.040

Purchased

No

100

sf

317.1300

0.049

0.103158

M6061T6S 040

DAS
46
9-89

16/11/17

6061-T6 .040 Sheet

Location

Loc Qty

Loc Code

MAT021

317.13

m135147

1

m135612

39.61

m135632

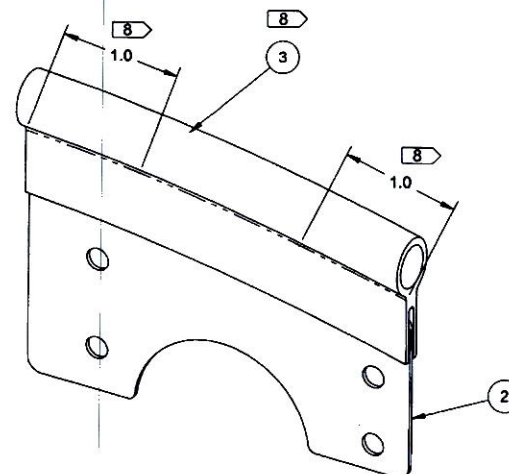
103.7

m135724

172.82

0.13

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4435-043	MOUNT BRACKET ASSEMBLY
2	1	D4435-3	BRACKET
3	1	D4441-1-037	RUBBER SEAL
4	A/R	3M 1300/1300L	ADHESIVE



D4435-043 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs
- 8) GLUE RUBBER SEAL TO BRACKET EDGE USING 3M 1300/1300L ADHESIVE, EXCEPT 1.0" FROM EACH END. ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL

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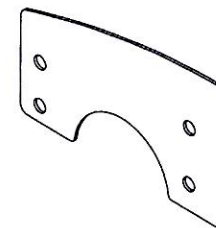
WITHOUT NOTICE
WORK ORDER

NO. 153078 MLJ

16-11-09

RELEASED
2012-03-03

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>E</i>	D4435	SHEET 2 OF 11
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	BRACKET	NTS
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2012-03-02

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MFG. APPR.	<i>RF</i>	D4435	SHEET 5 OF 5
APPROVED	<i>RF</i>	TITLE	SCALE
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